



Dart Aerospace Ltd.
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K6A 1K7
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RB DB3225L-11
Job Sheet 190789



Part No: RB DB3225L-11

Job Qty: 5 pcs

Part Name: T/R Gearbox and Freewheeling Adapter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/15/19

Job Tracking No:

Due Date: 3/14/19 March 28

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB DB3225L Rev.J IPP Rev. A 19.02.12 New issue DP Verify DD

Ship Via:

Bill of Materials



Container No: S164422



Part: RB DB3225L - 11

Job No: 190789

Serial No/Batch: S164422

Revision: J

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/20/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	5 pcs	3/1/19		0.00	1.00	Small Fab - 1		
							Small Fab - 2		MCC
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	5 pcs	3/1/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Packaging 3-1 - Stock - B4B	5 pcs	3/1/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - SA	5 pcs	3/1/19		0.00	0.00	QC 21 - SA - 21		
							QC 21 - SA - 70		
							QC 21 - SA - 53		

Part Op Descriptions: 100 - Assemble as per DWG. See note 8 through 12.

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MAR 20 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
9464K16	O-Ring	5 Ea (1 ea)	100-Small Fab - 1	5021600
9464K17	O-Ring, Ø1/16 X 0.364 I.D.	5 Ea (1 ea)	100-Small Fab - 1	4145163
RB DB3225L-1	Fitting End	5 pcs (1 ea)	100-Small Fab - 1	3154032
RB DB3225L-3	Rotational Connector	5 pcs (1 ea)	100-Small Fab - 1	5154388
RB DB3225L-5	Hose End	5 pcs (1 ea)	100-Small Fab - 1	5154500

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Internal Ring

5 pcs (1 ea each)

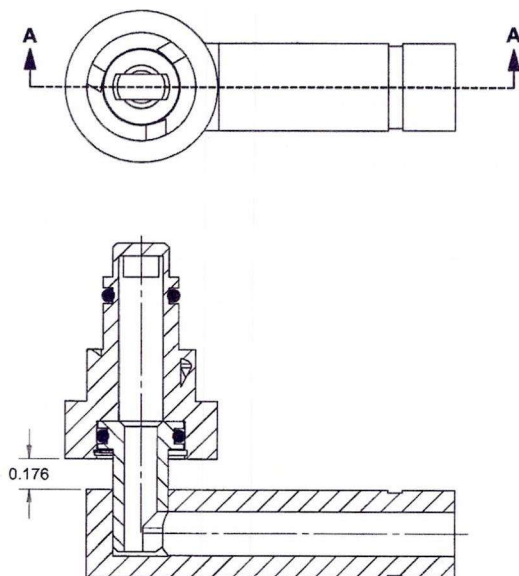
5152171

8751

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	9464K16	5	200	0
	9464K17	5	100	0
	RB DB3225L-1	5	23	0
	RB DB3225L-3	5	0	0
	RB DB3225L-5	5	0	0
Part Specifications				
Specifications could not be found.				

Plex 2/15/19 8:01 AM Dart.lajeunesse.marie

ITEM #	QTY	PART #	PART TITLE
-1	1	RB DB3225L-1	FITTING END
-3	1	RB DB3225L-3	ROTATIONAL CONNECTOR
-5	1	RB DB3225L-5	HOSE END
17	1	Smalley#WH-50 OR EQUIV.	INTERNAL RING 0.532" OD. X 0.025" THK.
18	1	McMaster#9464K16 OR EQUIV.	VITON O-RING 5/16" ID X 7/16" OD X 1/16" THK
19	1	McMaster#9464K17 OR EQUIV.	VITON O-RING 3/8" ID. X 1/2" OD. X 1/16" THK.

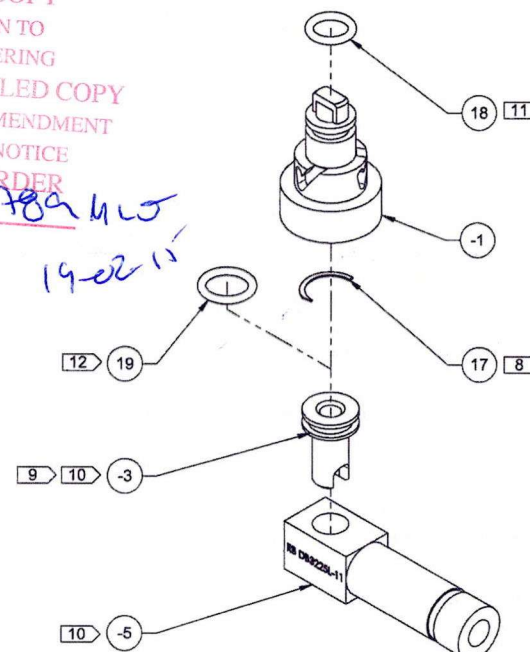


SECTION A-A

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) ITEM 17 SHALL BE CUT IN HALF TO FIT
 - 9) WHEN PRESSING ITEM -3 INTO ITEM -5 ALIGN CUTOUT AS SHOWN
 - 10) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM -3 WITH ITEM -5 AND REMOVE EXCESS
 - 11) APPLY MOLYKOTE 55 O-RING GREASE OR EQUIVALENT ON ITEM 18 THEN ASSEMBLE WITH ITEM -1 AND REMOVE EXCESS
 - 12) APPLY MOLYKOTE 55 O-RING GREASE OR EQUIVALENT ON ITEM 19 THEN ASSEMBLE WITH ITEM -3 AND REMOVE EXCESS

-GA045

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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 190789415
19-02-15



RB DB3225L-11 T/R GEARBOX AND FREEWHEELING ADAPTER ASSY

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. J
MFG. APPR.	JFC	RB DB3225L	SHEET 3 OF 9
APPROVED	VJP	TITLE	SCALE
		T/R GEARBOX AND FREEWHEELING ASSY DRAIN	NTS
		TOOL	
DATE	2/11/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					